

Work Order ID 78174

78174

Page 1

January-02-12 8:14:50 AM

Item ID: D3943-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Extension

Start Date: 02/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/02 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3943

E

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3943

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

B 12-1-16

(20)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B 12-1-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Item Name: Handle Extension
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		812/01/17		cauls (720)			
130 *130* HAAS I HAAS CNC vertical machine #1	Memo MILL AS PER DWG AND FOLIO FA915 FOLIO REV: _____ DWG REV: _____ Manual	0.00 0.00		12/01/24		20			
	2-MILL DIMPLE USING 3/8" BALL MANUALLY			12/01/18					
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		812/01/25		cauls (720)			

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 Item Name: Handle Extension
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST. 73</u>	0.00							
170									
Packaging	Memo	0.00							<u>12-1-24</u> <u>X20</u>
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							<u>12/1/25</u> <u>98</u>
Quality Control									<u>PL 12-01-24</u> <u>60</u>

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Picklist Print

January-02-12 8:14:54 AM

Page 1

Work Order ID: 78174

78174

Parent Item: D3943-3

D3943-3

Parent Item Name: Handle Extension

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: Est Rev:A New Issue 09-06-03 JLM. Verified By:EC IPP Rev:B as
per dwg REV.C DD 10.02.22 verified by:EC IPP REV:C 11.08.16 AS
PER REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X012.000		Purchased	No			100	f	61.0000	1.26	5.305263	25.5		
M304B0 500X012 000										**	1312-1-16		
304 BAR .500 X 12.00													

Location

Loc Qty

Loc Code

MAT050

61

112778

43

116061

18

112778 X 20
~~116061 X 18~~

W/O:		WORK ORDER CHANGES					
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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
16			1	D4405-1	EYE AND FORK SWIVEL	
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 0.75 LG	HASKINS
54	1			HX-16	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

SHOW COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 78174 M.C.J
12/01/02

RELEASED
 2011-07-29
mw

E	CHANGED D3945-3 MAT'L TO SS (B8-5); FINISH NOW "NONE" (A7-5); TAP DRILL FOR 1/4-20 UNF-2B WAS PILOT HOLE NOTE (B1-5). PER PAR11-113.	MB	11.07.27
D	SHT 1 PL, ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED). SHT 2 ZN D3 FLAG RELOCATED. SHT 3 ZONE D3, Ø0.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2). ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5). ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1). PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. E
CHECKED	<i>ASS</i>	D3943	SHEET 1 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.07.27		

W/O:		WORK ORDER CHANGES					
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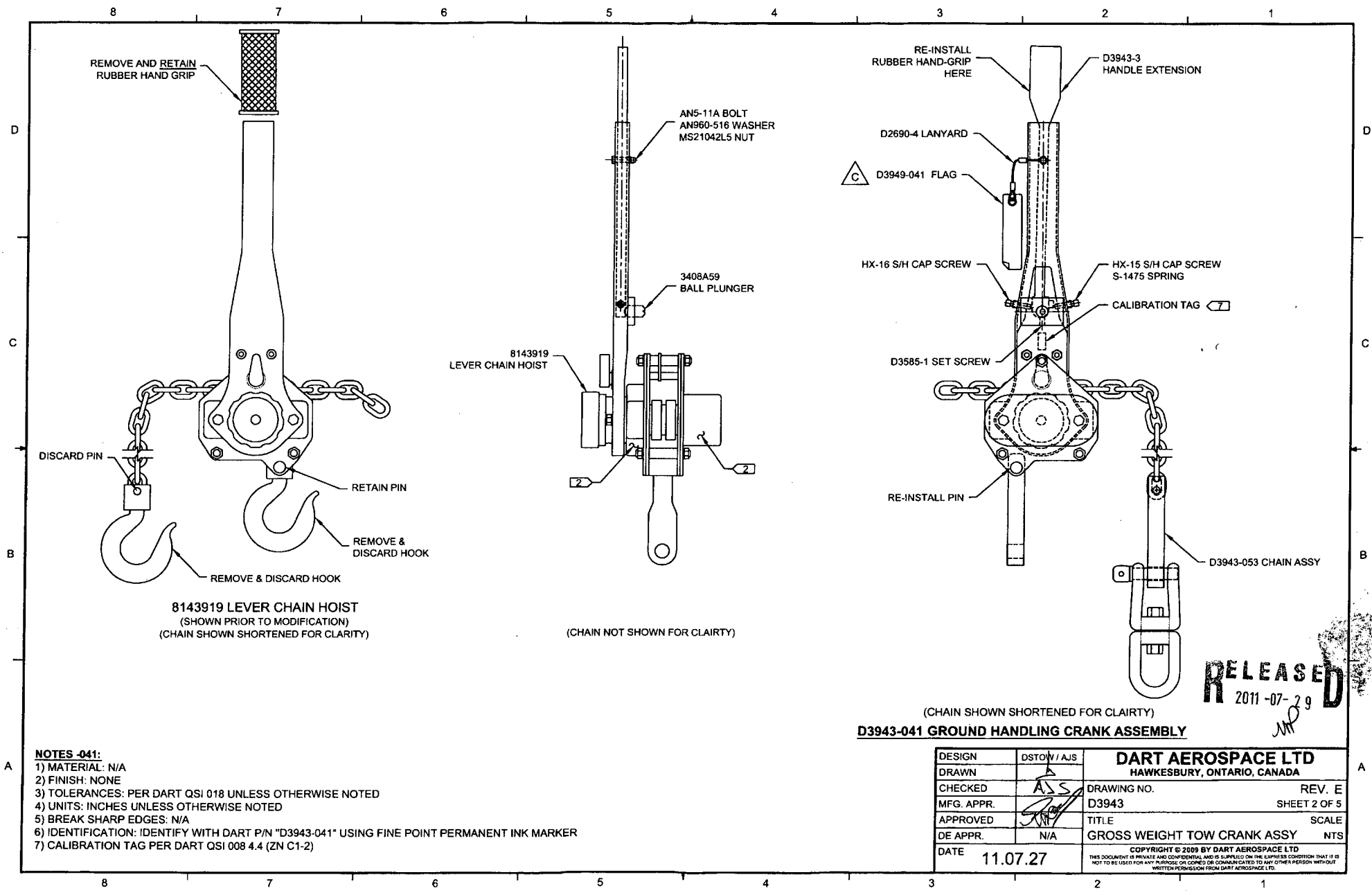
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

38174



RELEASED
2011-07-29

D3943-041 GROUND HANDLING CRANK ASSEMBLY

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS	DRAWING NO. D3943	REV. E SHEET 2 OF 5
CHECKED		TITLE GROSS WEIGHT TOW CRANK ASSY	SCALE NTS
MFG. APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED		DATE 11.07.27	
DE APPR.	N/A		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

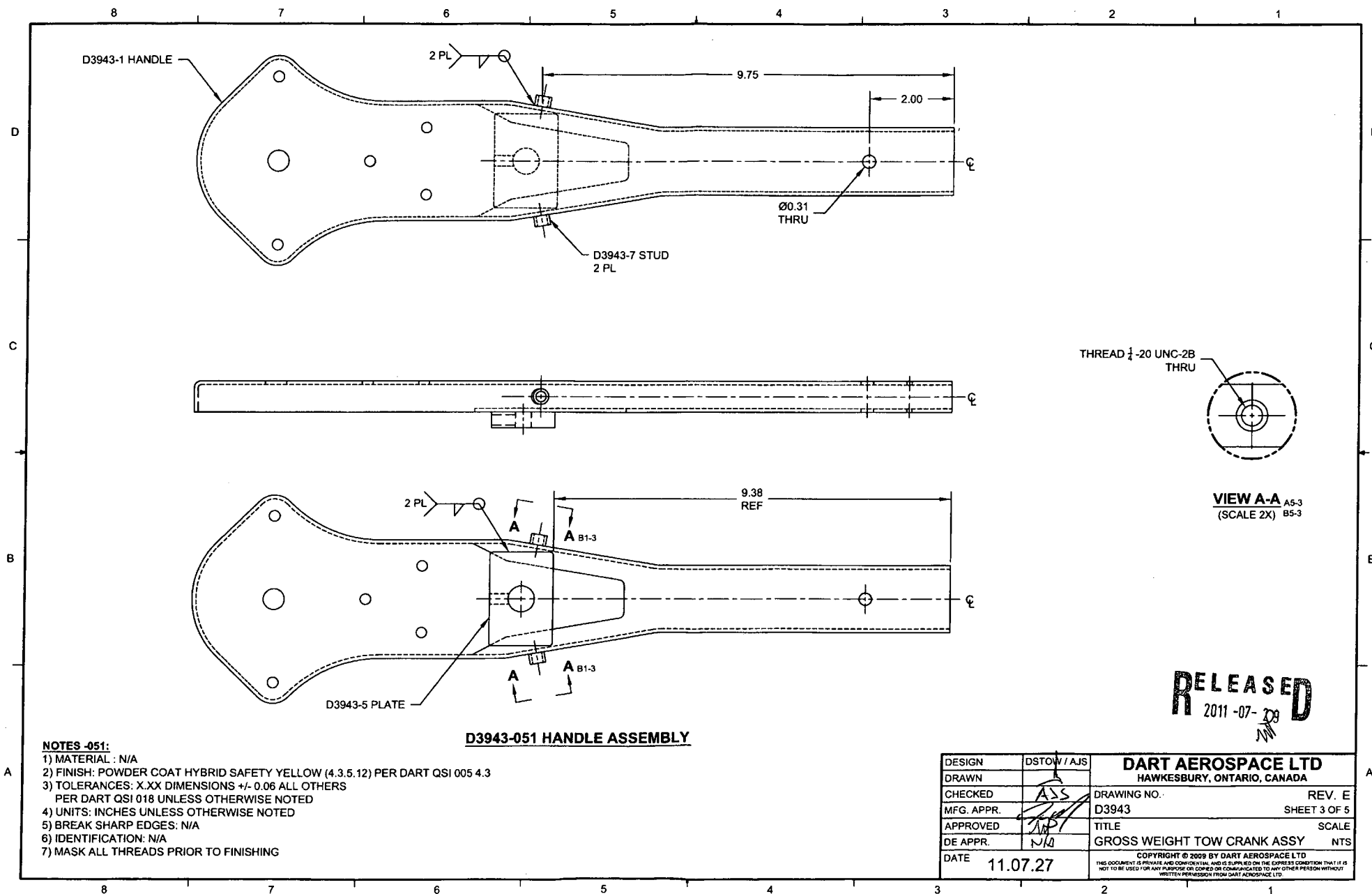
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78174



NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO FINISHING

D3943-051 HANDLE ASSEMBLY

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS	DRAWING NO.	REV. E
CHECKED	ASS	D3943	SHEET 3 OF 5
MFG. APPR.	ASS	TITLE	SCALE
APPROVED	ASS	GROSS WEIGHT TOW CRANK ASSY	NTS
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DATE	11.07.27		

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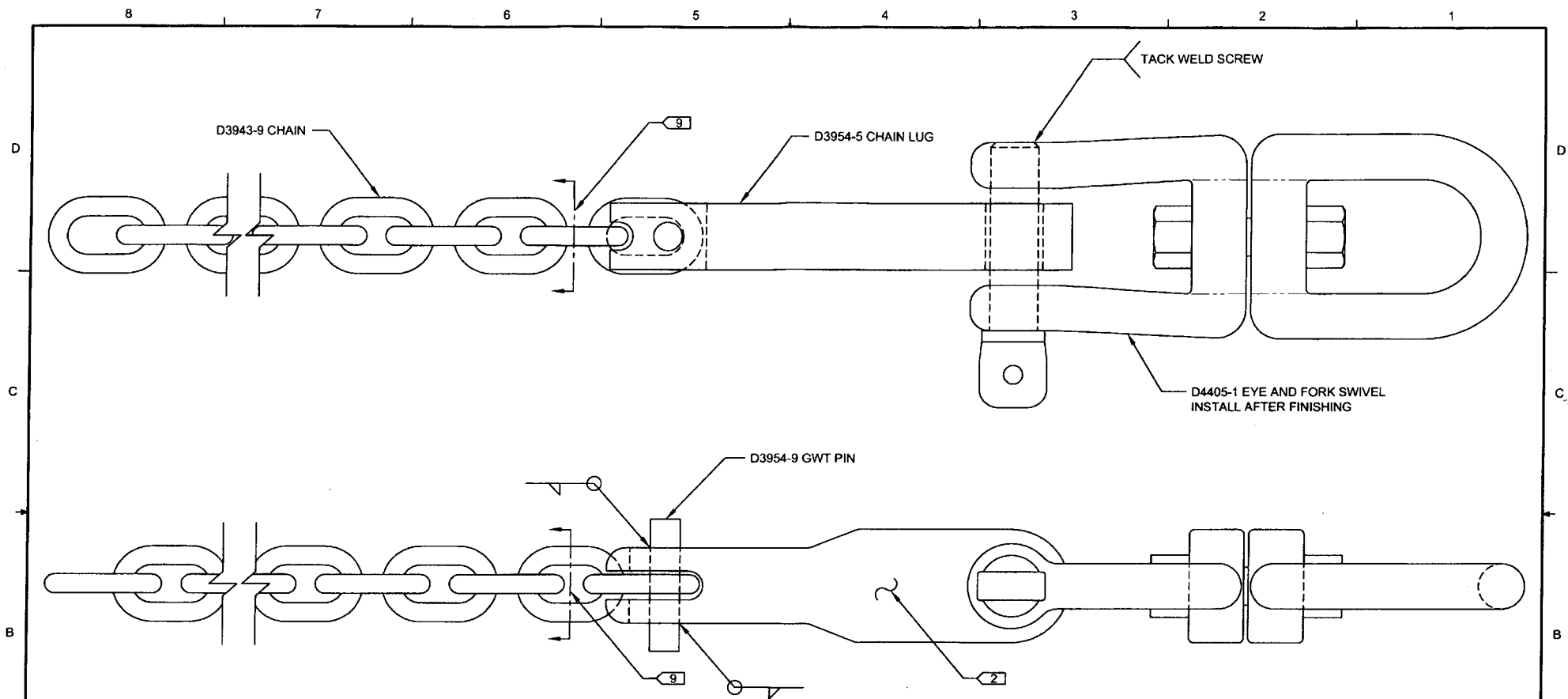
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78174



D3943-053 CHAIN ASSEMBLY

NOTES -053:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER QSI 004
- 9) MASK CHAIN FROM THIS POINT ON PRIOR TO FINISHING

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2011-07-28
MD

DESIGN	DSTON / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS	DRAWING NO.	REV. E
CHECKED	ASS	D3943	SHEET 4 OF 5
MFG. APPR.	ASS	TITLE	SCALE
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DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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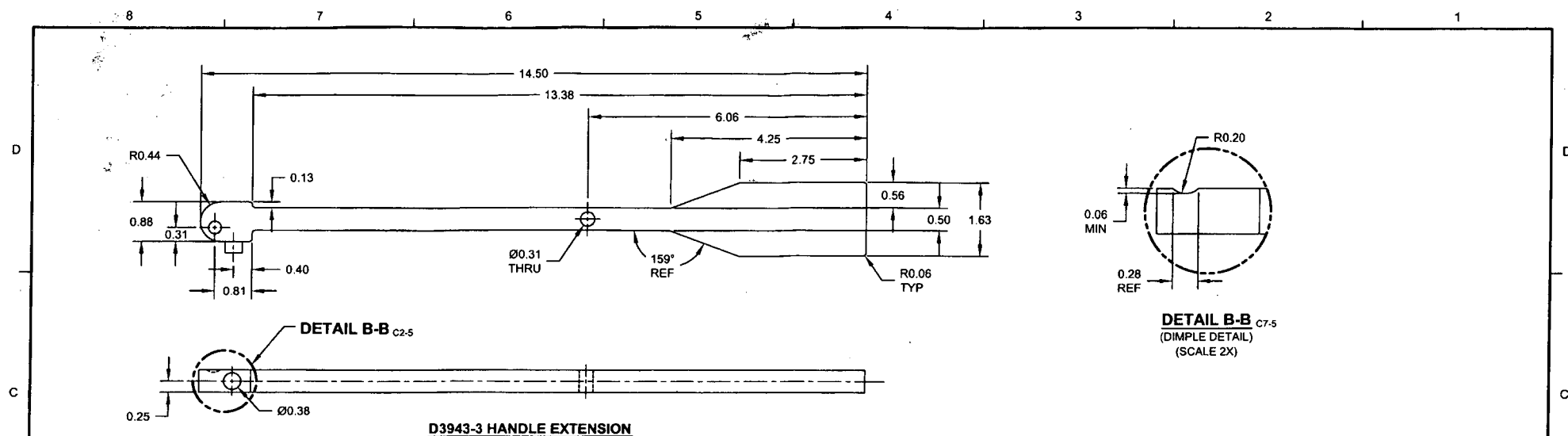
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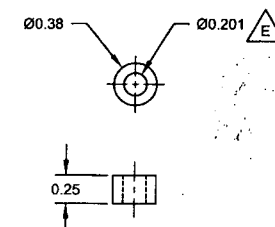
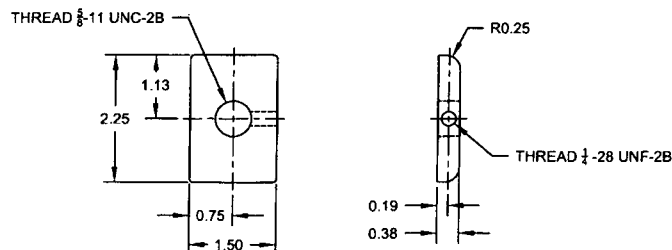
NOTES:

1) MATERIAL -3: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
OR:
AISI 303 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
ASTM A240 OR ASME SA240
REF DART SPEC M303S

-5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
OR:
MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A



RELEASED
2011-07-28
N/A

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